

Work Order ID 81117

March-08-12 8:52:21 AM

81117

Page 1

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 08/03/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLT Date: 12/03/09 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	1

100 MORI SEIKI CNC LATHE LARGE 0.00

100
 Mori Seiki Memo 0.00
 Mori Seiki CNC Lathe Large Turn as per Folio FA599 Rev: A & Dwg D3391 Rev: I
 scribe batch # on fwd end at 90 degree

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110
 QC Memo 0.00
 Quality Control

111 QC8- Inspect parts - second check 0.00

111
 QC Memo 0.00
 Quality Control ***INSPECT INSIDE BORE***

1 Ø
M.M.L 12/03/20
1 Ø
M.M.L 12/03/20
1 Ø
12/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr	0.00 0.00							<u>1</u> <u>0</u> <u>mant</u> <u>12/03/2024</u> <u>SK</u>
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							<u>1</u> <u>0</u> <u>mant</u> <u>12/03/2024</u> <u>SK</u>
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo ***INSPECT INSIDE BORE***	0.00 0.00							<u>B.A</u> <u>12/03/26</u> <u>1</u> <u>0</u>

W/O:		WORK ORDER CHANGES					
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Start Date: 08/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160		0.00							
160	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170		0.00							
170	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

CF 12-3-27

DL 12/03/27

4.08"

DP 12-3-27

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Skidtubes

0.00

Skidtubes

Memo

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

DC 12/04/02

DC 12/04/03

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		512/4/13					
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							2/6 12-4-3
210 *210* QC Quality Control	QC3- Inspect Part Finish QC7 Memo	0.00 0.00							12-4-4

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Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00

220

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: 120 666
exp. date: 13 -/- 30
cure time 12hrs as per QSI0015

DC 12/04/04

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

Sizelvelos

235

Pressure Wash per QSI005 4.3

0.00

235

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

Kp M. 12/04/05

W/O:		WORK ORDER CHANGES					
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1

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat									
Powder Coating	Memo	0.00							
	START TIME: 10h45								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 11h45								
		M120222							
250	QC3- Inspect Part Finish	0.00							
250									
QC									
Quality Control	Memo	0.00							
260	HandFinishing	0.00							
260									
HandFinish									
Hand Finishing	Memo	0.00							
	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241/-291 M110310								
	Sikaflex expiry date: 12/09								
	3- INSTALL WEARPLATES AS PER DWG								

1 2 12/04/06

1 2 12/04/09

1 2 12/04/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Item Name: Aft Tube Assembly

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1

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control									
280	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
280									
Packaging	Memo	0.00							
Packaging									
290	QC21- Final Inspection - Work Order Release	0.00							
290									
QC	Memo	0.00							
Quality Control									

12/4/10

112-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:
 IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047

Manufactured

No

260

Each

19.0000

1

1

D4095-047

Wearpad Assembly

**

mu 12/03/09

Location

Loc Qty

Loc Code

FP002

19

78325

5

80703

14

D4095-049

Manufactured

No

260

Each

15.0000

1

1

D4095-049

Wearpad Assembly

**

mu 12/03/09

Location

Loc Qty

Loc Code

FP002

15

80704

15

D6014-090

Manufactured

No

100

Each

43.0000

1

1

D6014-090

ALUMINUM EXTRUSION

**

Location

Loc Qty

Loc Code

LG

43

17332

43

1 am 12/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

63.0000

4

4

D3670-4-200

SPACER

**

12C 12/04/09

Location

B 80360

Loc Qty

Loc Code

LG001

63

72851

3

77500

4

78606

56

4

D2646

Manufactured No

270

Each

146.0000

1

1

D2646

Aft Cap

**

12C 12/04/09

Location

Loc Qty

Loc Code

FP002

146

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

33

79500

47

79562

50

12

D3672-1

Manufactured No

270

Each

1,294.000

2

2

D3672-1

Phenolic Washer

**

12C 12/04/09

Location

Loc Qty

Loc Code

FP001

242

66821

242

ST060

1052

72229

52

76277

500

80369

500

12

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Shop Packet Print

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D3391-025

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

4,855.000

14

14

AI S4-1032-130

Insert

**

20 104104

Location

Loc Qty

Loc Code

ST280

681

119084

116

120671

565

ST281

4174

120410

174

120807

2000

120837

2000

114

ALS4-1032-225

Purchased

No

270

Each

1,194.000

8

8

AI S4-1032-225

Insert

**

20 104104

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

163

120410

150

120451

13

18

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Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

270 Each

3,729.000 6 6

AN3C4A

BOLT

**

ul nlouloq

Location

Loc Qty

Loc Code

ST350

3729

117688

5

118112

16

119749

10

120187

2000

120423

10

120521

510

120769

515

120799

163

120930

500

AN3C5A Purchased No

270 Each

1,010.000 4 4

AN3C5A

Bolt

**

ul nlouloq

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1003

116419

28

117343

13

117764

7

117872

2

119749

23

120423

930

AN960C10L NAS1149C0332 Purchased No

270 Each

0.0000 10 10

***AN960C10I ***

washer

**

11121255 6101 ul nlouloq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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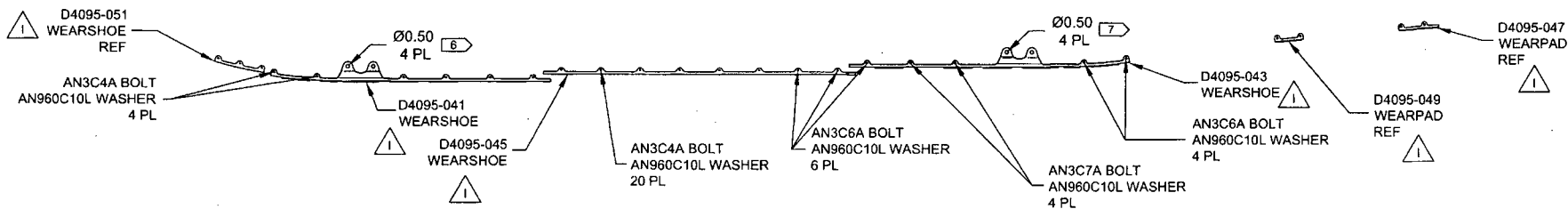
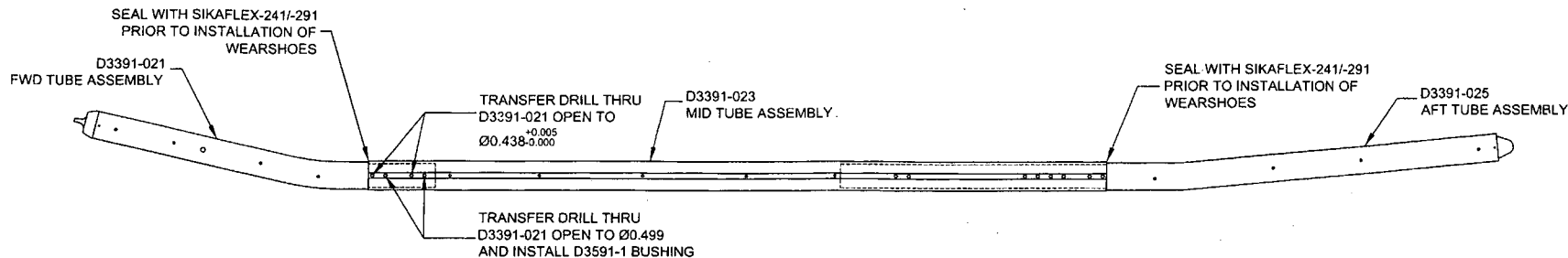
W/O:		WORK ORDER CHANGES					
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST


QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4393-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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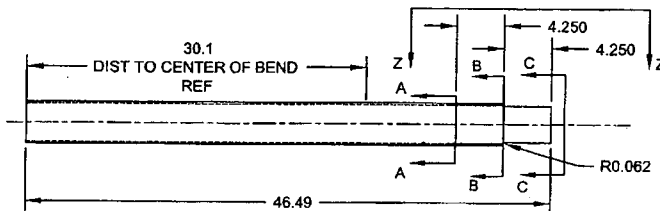
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

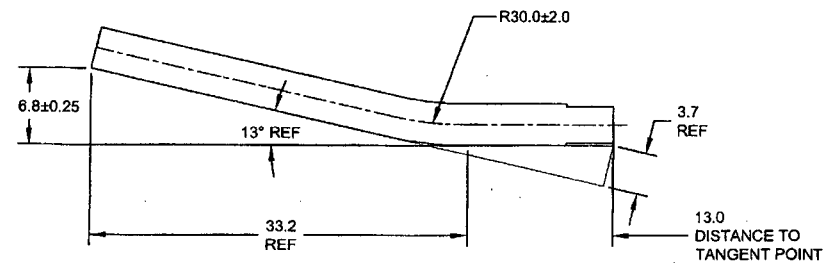
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

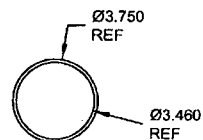
NOTE: Date & initial all entries



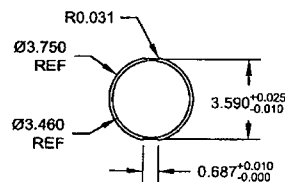
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



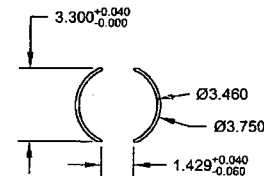
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



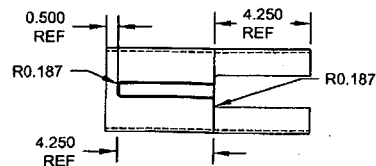
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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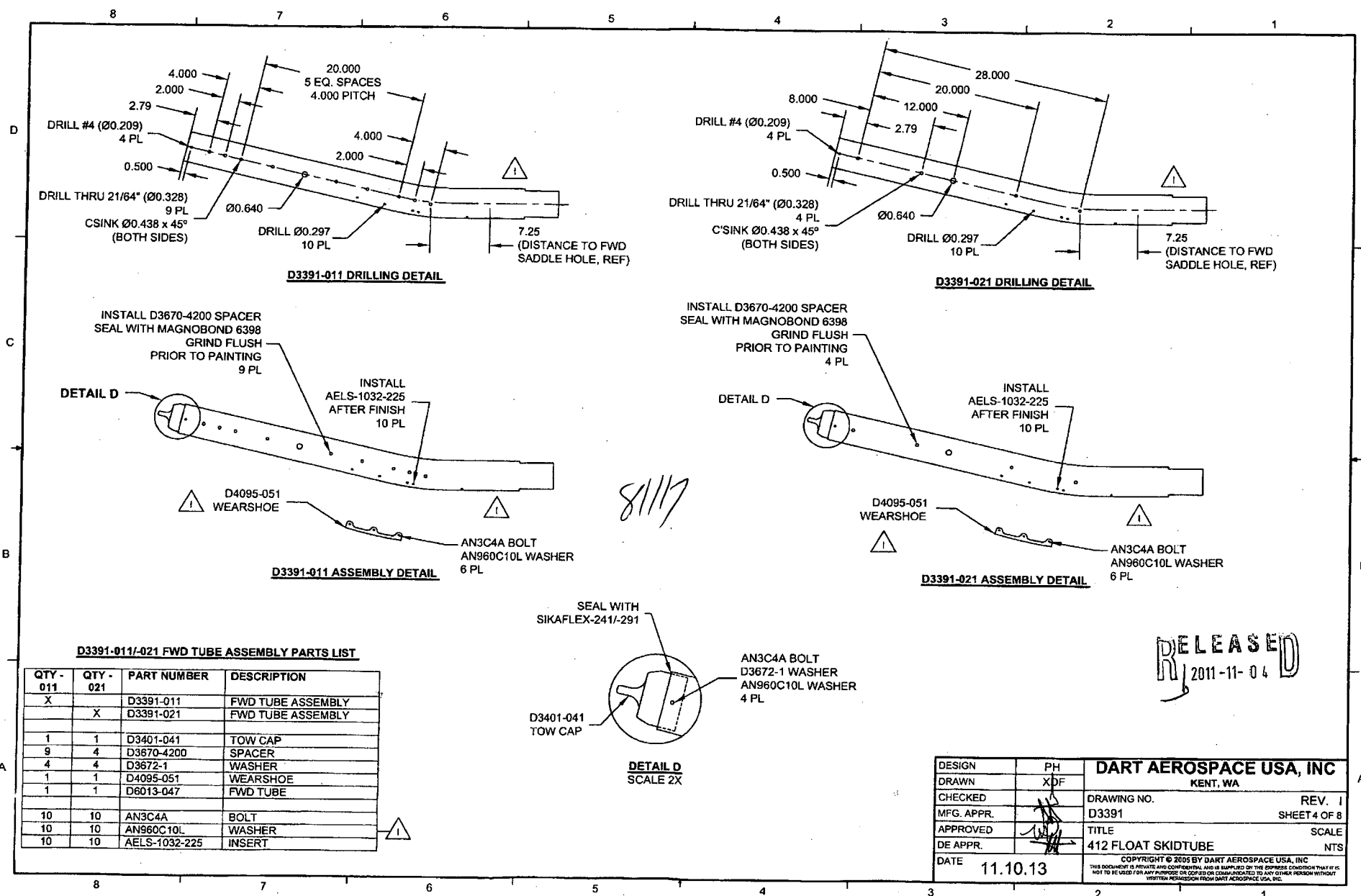
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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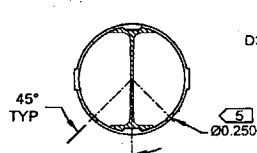
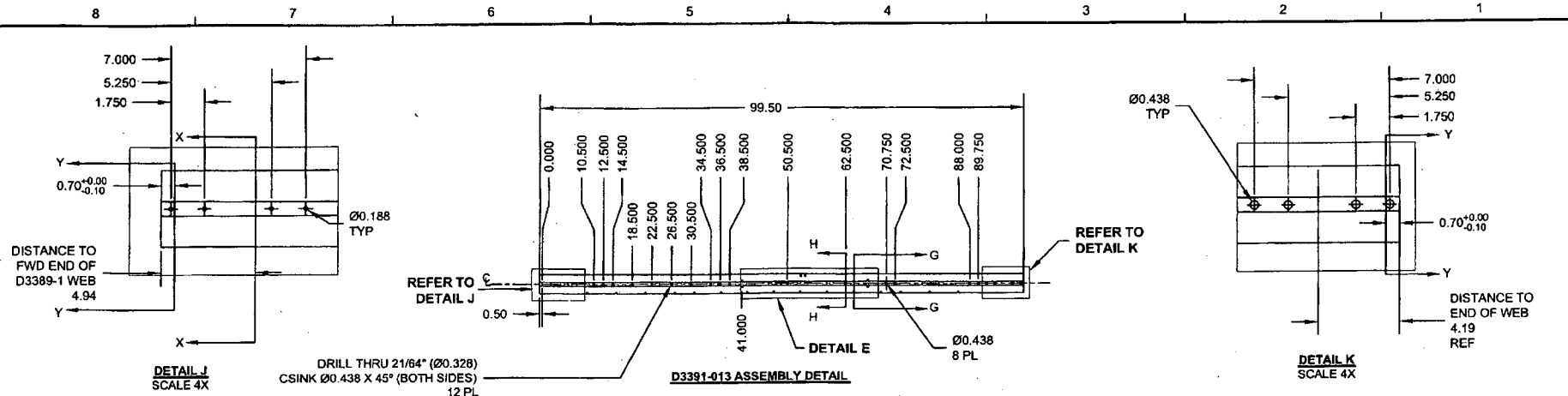
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

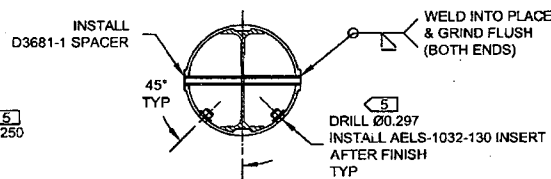
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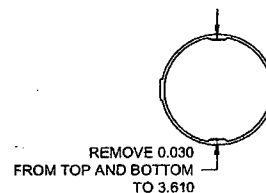
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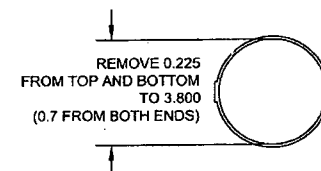
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



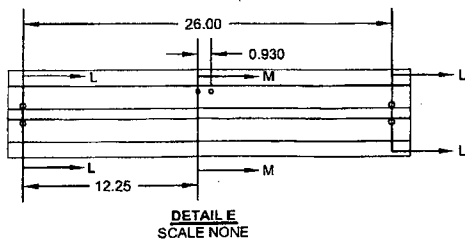
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

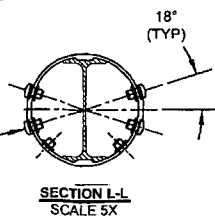
QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

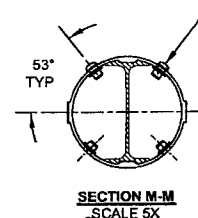
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004



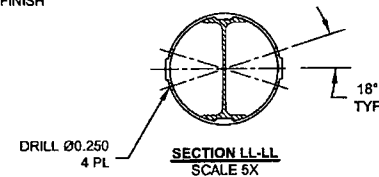
DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X

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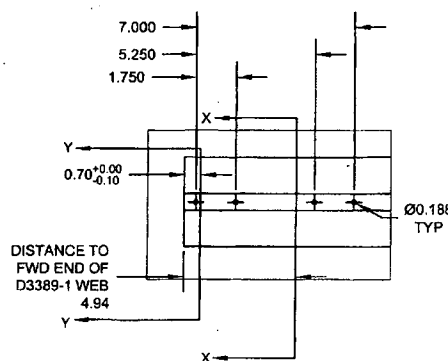
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

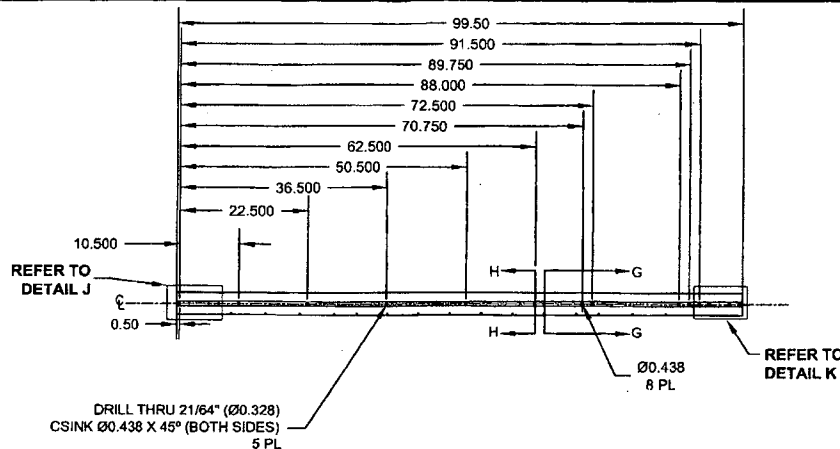
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

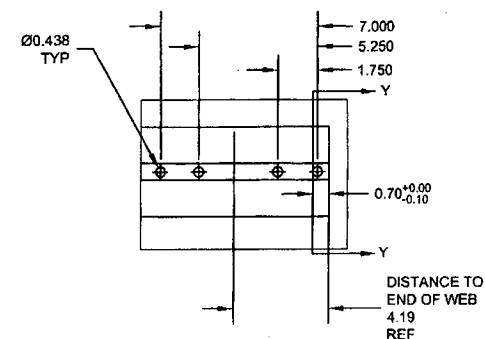
NOTE: Date & initial all entries



DETAIL J
SCALE 4X



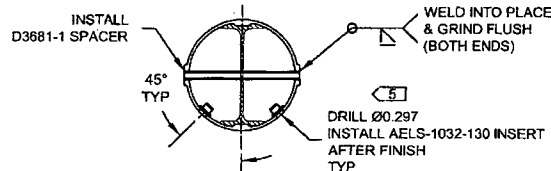
D3391-023 ASSEMBLY DETAIL



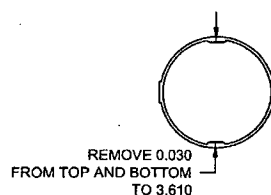
DETAIL K
SCALE 4X



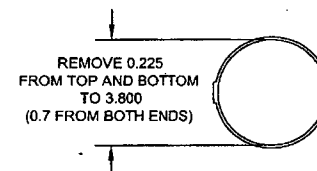
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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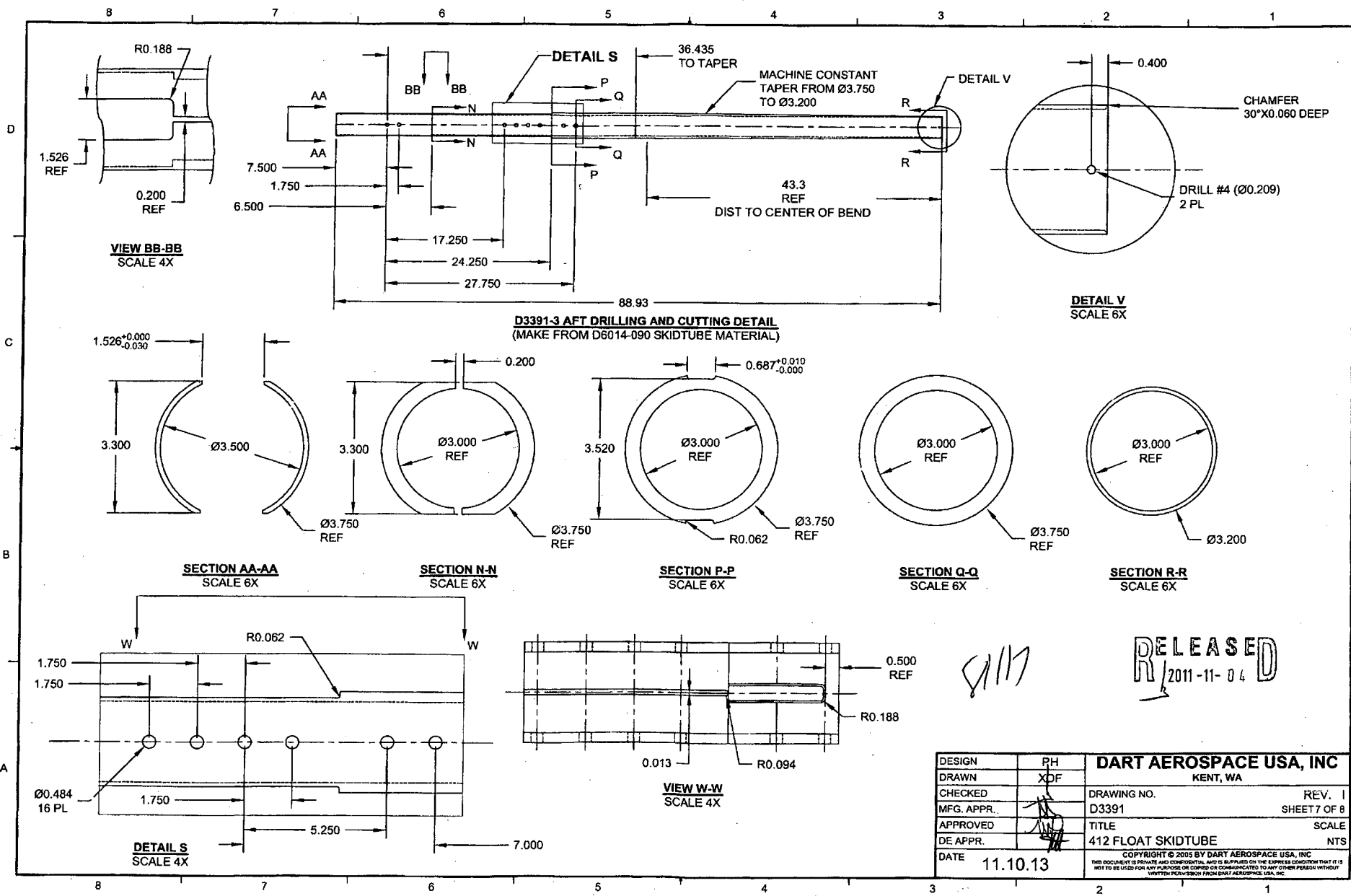
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



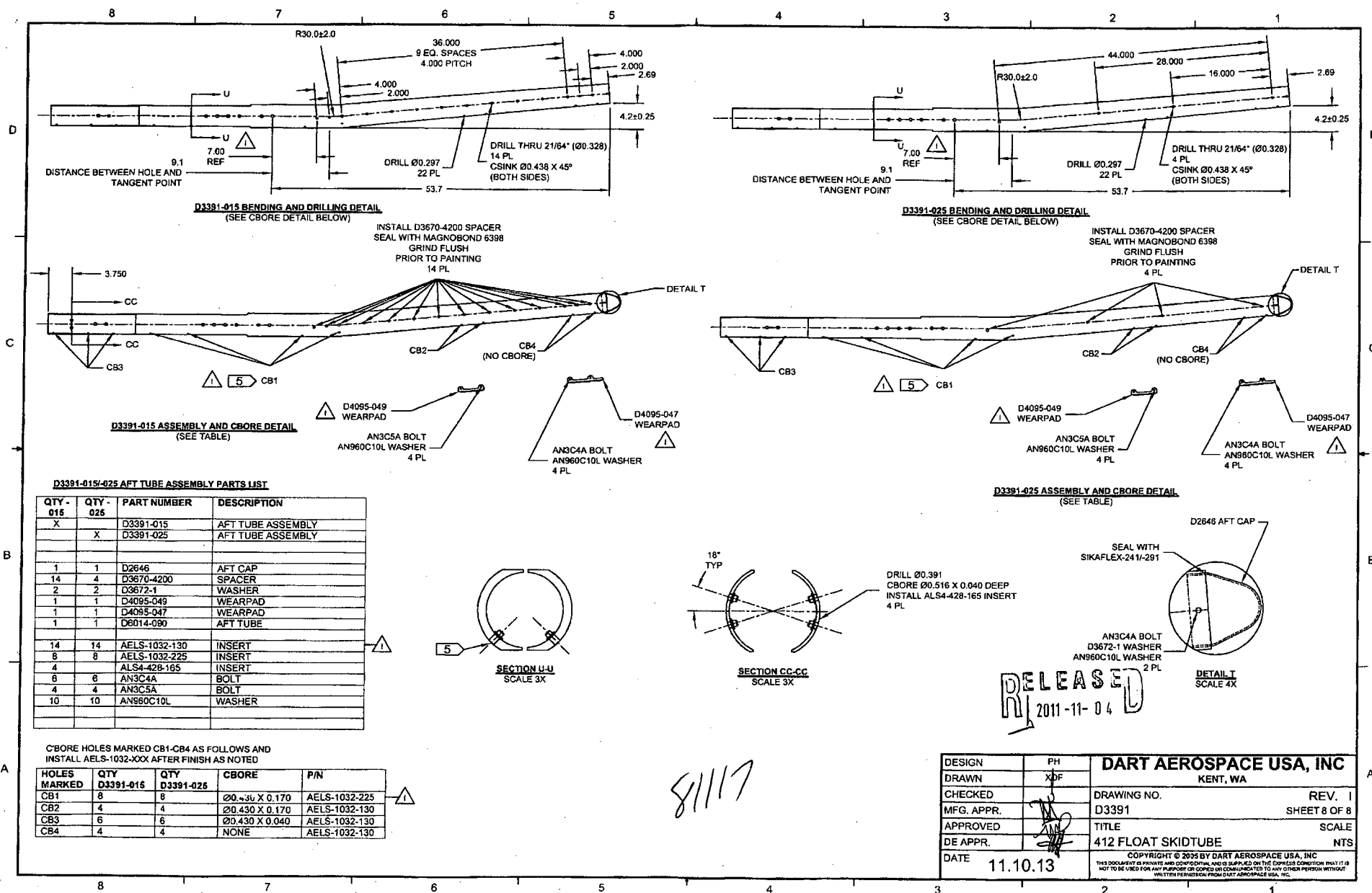
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81117
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: H I <i>4/11</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	MM/L-02
3.500	+/-0.010	3.499	✓		vern	CAL-06
88.93	+/-0.030	88.936	✓		tape	MM/L-02
Ø3.200	+/-0.010	3.199			vern	CAL-06
88.93	+/-0.030	88.936	✓		tape	MM/L-02
Ø3.750	+/-0.010	3.750	✓		vern	CAL-06
30° x 160" chamfer	+/-0.010	30° x 160	✓		"	

Measured by: <i>MM</i>	Date: 12/03/17
Audited by: <i>SK</i>	Date: 12/03/17

HAAS Section						
1.526	+0.000/-0.030	1.505			Caliper	BK 07
7.500	+/-0.010	7.502				"
27.750	+/-0.010	27.750			Tape	BK 09
31.750	+/-0.010	31.750				"
35.250	+/-0.010	35.250				"
3.300	+/-0.010	3.302				BK 07
0.200	+/-0.010	.195				"
3.520	+/-0.010	3.521				"
0.687	+0.010/-0.000	.687				"
R0.062	+/-0.010	.062				"
Ø0.484	+0.005/-0.001	.484				"

Measured by: <i>SK</i>	Date: 12/03/17
Audited by: <i>HA</i>	Date: 12/03/17

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

W/O:		WORK ORDER CHANGES					
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